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**646.9702**  
**Job Sheet 214164**



Part No: 646.9702

Job Qty: 2 pcs

DAS  
21  
9-83

Part Name: Cutter Sub Assembly (U Channel)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/20/20

Job Tracking No:

Due Date: 12/18/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG 646.9702 REV.J IPP REV:A NEW ISSUE JFS 13/07/03 VERIFY BY: DD IPP REV:B 2020.05.27 AS PER  
DWG REV.J DD VERF:JFS

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation              | Qty      | Start Date | Due Date | Standard  |         | Workcenter/Supplier         |           | Sign-off           |
|-------|------------------------|----------|------------|----------|-----------|---------|-----------------------------|-----------|--------------------|
|       |                        |          |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier       | Lead Time |                    |
| 110   | Packaging 1 - Pick Kit | 2<br>pcs |            | 12/17/20 | 0.00      | 0.00    | Packaging 1 - SCH-S         |           | DAS 58 NOV 10 2020 |
| 120   | Small Fab - 2 - B4B    | 2<br>pcs |            | 12/18/20 | 0.00      | 1.13    | Small Fab - 1 - B4B         |           | DAS 58 NOV 10 2020 |
|       |                        |          |            |          |           |         | Small Fab - 2 - B4B         |           |                    |
|       |                        |          |            |          |           |         | Small Fab - 3 - B4B         |           |                    |
|       |                        |          |            |          |           |         | Small Fab - 4 - B4B         |           |                    |
|       |                        |          |            |          |           |         | Small Fab - 5 - B4B         |           |                    |
|       |                        |          |            |          |           |         | Small Fab - 6 - B4B         |           |                    |
|       |                        |          |            |          |           |         | Small Fab - 7 - B4B         |           |                    |
|       |                        |          |            |          |           |         | Small Fab - 8 - B4B         |           |                    |
|       |                        |          |            |          |           |         | Small Fab - 9 - B4B         |           |                    |
|       |                        |          |            |          |           |         | Small Fab - Various 1 - B4B |           |                    |
| 130   | QC 5                   | 2<br>pcs |            | 12/18/20 | 0.00      | 0.00    | QC 5 - 10                   |           |                    |
|       |                        |          |            |          |           |         | QC 5 - 12                   |           |                    |
|       |                        |          |            |          |           |         | QC 5 - 17                   |           |                    |
|       |                        |          |            |          |           |         | QC 5 - 18                   |           |                    |
|       |                        |          |            |          |           |         | QC 5 - 19                   |           |                    |
|       |                        |          |            |          |           |         | QC 5 - 22                   |           |                    |
|       |                        |          |            |          |           |         | QC 5 - 24                   |           |                    |
|       |                        |          |            |          |           |         | QC 5 - 3                    |           |                    |
|       |                        |          |            |          |           |         | QC 5 - 43                   |           |                    |
|       |                        |          |            |          |           |         | QC 5 - 49                   |           |                    |
|       |                        |          |            |          |           |         | QC 5 - 51                   |           |                    |
|       |                        |          |            |          |           |         | QC 5 - 58                   |           |                    |
|       |                        |          |            |          |           |         | QC 5 - 68                   |           |                    |
|       |                        |          |            |          |           |         | QC 5 - 9                    |           |                    |
|       |                        |          |            |          |           |         | QC 5 - 50                   |           |                    |
|       |                        |          |            |          |           |         | QC 5 - 30                   |           |                    |
|       |                        |          |            |          |           |         | QC 5 - 40                   |           |                    |
|       |                        |          |            |          |           |         | QC 5 - 61                   |           |                    |

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|                                 |                           |          |           |                        |                                  |
|---------------------------------|---------------------------|----------|-----------|------------------------|----------------------------------|
| 140 Packaging 3-1 - Stock - B4B | 2<br>pcs<br>4 pcs<br>M.R. | 12/18/20 | 0.00 0.00 | QC 5 - 81              | NOV 11 2020                      |
|                                 |                           |          |           | QC 5 - 82              |                                  |
|                                 |                           |          |           | Packaging 3 - 1 - B4B  | DAS<br>23<br>9-89<br>NOV 11 2020 |
|                                 |                           |          |           | Packaging 3 - 2 - B4B  |                                  |
|                                 |                           |          |           | Packaging 3 - 3 - B4B  |                                  |
|                                 |                           |          |           | Packaging 3 - 4 - B4B  |                                  |
|                                 |                           |          |           | Packaging 3 - 5 - B4B  |                                  |
|                                 |                           |          |           | Packaging 3 - 6 - B4B  |                                  |
|                                 |                           |          |           | Packaging 3 - 7 - B4B  |                                  |
|                                 |                           |          |           | Packaging 3 - 8 - B4B  |                                  |
|                                 |                           |          |           | Packaging 3 - 9 - B4B  |                                  |
|                                 |                           |          |           | Packaging 3 - 10 - B4B |                                  |
|                                 |                           |          |           | Packaging 3 - 11 - B4B |                                  |
|                                 |                           |          |           | Packaging 3 - 12 - B4B |                                  |
|                                 |                           |          |           | Packaging 3 - 13 - B4B |                                  |
|                                 |                           |          |           | Packaging 3 - 14 - B4B |                                  |
|                                 |                           |          |           | Packaging 3 - 15 - B4B |                                  |
|                                 |                           |          |           | Packaging 3 - 16 - B4B |                                  |
|                                 |                           |          |           | Packaging 3 - 17 - B4B |                                  |
|                                 |                           |          |           | Packaging 3 - 18 - B4B |                                  |
|                                 |                           |          |           | Packaging 3 - 19 - B4B |                                  |
|                                 |                           |          |           | Packaging 3 - 20 - B4B |                                  |
|                                 |                           |          |           | Packaging 3 - 21 - B4B |                                  |
|                                 |                           |          |           | Packaging 3 - 22 - B4B |                                  |
|                                 |                           |          |           | Packaging 3 - 23 - B4B |                                  |
|                                 |                           |          |           | Packaging 3 - 24 - B4B |                                  |
|                                 |                           |          |           | Packaging 3 - 25 - B4B |                                  |
|                                 |                           |          |           | Packaging 3 - 26 - B4B |                                  |
|                                 |                           |          |           | Packaging 3 - 27 - B4B |                                  |
|                                 |                           |          |           | Packaging 3 - 28 - B4B |                                  |
|                                 |                           |          |           | Packaging 3 - 29 - B4B |                                  |
|                                 |                           |          |           | Packaging 3 - 30 - B4B |                                  |
|                                 |                           |          |           | Packaging 3 - 31 - B4B |                                  |
|                                 |                           |          |           | Packaging 3 - 32 - B4B |                                  |
|                                 |                           |          |           | Packaging 3 - 33 - B4B |                                  |
|                                 |                           |          |           | Packaging 3 - 34 - B4B |                                  |
|                                 |                           |          |           | Packaging 3 - 35 - B4B |                                  |
|                                 |                           |          |           | Packaging 3 - 36 - B4B |                                  |
|                                 |                           |          |           | Packaging 3 - 37 - B4B |                                  |
| 150 QC 21 - SA                  | 2<br>pcs<br>4 pcs<br>M.R. | 12/18/20 | 0.00 0.00 | QC 21 - SA - 21        | DAS<br>21<br>9-89<br>NOV 11 2020 |
|                                 |                           |          |           | QC 21 - SA - 70        |                                  |
|                                 |                           |          |           | QC 21 - SA - 9         |                                  |
|                                 |                           |          |           | QC 21 - SA - 77        |                                  |
|                                 |                           |          |           | QC 21 - SA - 28        |                                  |

## Part Op 110 - (Pick Kit)

Descriptions: 120 - (Small Fab) Assemble as per dwg and apply loctite 598 on all faying surfaces per note . A/R RTV LOCTITE

598: 5304317 exp. date: 08/22

130 - (QC5- Inspect part completeness to step on W/O)

140 - (Identify as per dwg &amp; Stock Location: ) \*\*\*IDENTIFY AS PER IAW MPP-120\*\*\*

150 - (QC21- Final Inspection - Work Order Release)

018093

## Job BOM

| Part / Item       | Component Name   | Quantity         | Operation                  | Container        |
|-------------------|------------------|------------------|----------------------------|------------------|
| 646.9711 107      | Blade            | 8 1/2 pcs (2 ea) | 110-Packaging 1 - Pick Kit | 5301184          |
| 646.9712 1016     | Body             | 4 1/2 pcs (1 ea) | 110-Packaging 1 - Pick Kit | 532362710        |
| MS21042L08 5T303  | Nut              | 24 1/2 Ea (6 ea) | 110-Packaging 1 - Pick Kit | 53099714 5307361 |
| MS27039-08-19 615 | Screw            | 24 1/2 Ea (6 ea) | 110-Packaging 1 - Pick Kit | 5309811          |
| NAS1149FN832P 263 | Washer (AN960-8) | 48 24 Ea (12 ea) | 110-Packaging 1 - Pick Kit | 5309620          |

| Job Allocations                    |                |          |           |           |
|------------------------------------|----------------|----------|-----------|-----------|
| Operation                          | Component Part | Required | Inventory | Allocated |
| 110-Packaging 1 - Pick Kit         | 646.9711       | 4        | 26        | 0         |
|                                    | 646.9712       | 2        | 12        | 0         |
|                                    | MS21042L08     | 12       | 502       | 0         |
|                                    | MS27039-08-19  | 12       | 405       | 0         |
|                                    | NAS1149FN832P  | 24       | 1,219     | 0         |
| Part Specifications                |                |          |           |           |
| Specifications could not be found. |                |          |           |           |

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Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |  |                        |  |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|------------------------|--|
| Job: _____<br><br>Part No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> | <b>DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Water Jet <input type="checkbox"/><br/>           Supplier <input type="checkbox"/><br/>           Quality <input type="checkbox"/> </div> </div>                                                                                                                                                                                                                                                                      |  |                        |  |
| Date :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | Sequence #:                                                                                                                       | QTY Affected :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |  | MRB (QSI042)           |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                                                                                                                   | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |  | Completed By           |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |  | Lead hand / Supervisor |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |  |                        |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |  |                        |  |
| <b>Root Cause</b><br><br><div style="display: flex;"> <div style="flex: 1;">           Operator <input type="checkbox"/><br/>           Manufacturing Process <input type="checkbox"/><br/>           Equip/Tooling <input type="checkbox"/><br/>           Handling/Presservation <input type="checkbox"/><br/>           Material <input type="checkbox"/><br/>           Product Improvement <input type="checkbox"/><br/>           Process Improvement <input type="checkbox"/><br/>           Human Factors <input type="checkbox"/> </div> <div style="flex: 1;"> <input type="checkbox"/> Pressure/Forced<br/> <input type="checkbox"/> Bending<br/> <input type="checkbox"/> Crushing<br/> <input type="checkbox"/> Cracks<br/> <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist<br/> <input type="checkbox"/> Marks/Chatter<br/> <input type="checkbox"/> Mislabeled         </div> </div> |                                                                                                                                   | <b>FAULT CATEGORY</b><br><br><div style="display: flex;"> <div style="flex: 1;"> <input type="checkbox"/> Contamination<br/> <input type="checkbox"/> Misaligned/off center<br/> <input type="checkbox"/> BOM/Route<br/> <input type="checkbox"/> Broken/Damage/Defect<br/> <input type="checkbox"/> Incomplete/Unclear Instructions<br/> <input type="checkbox"/> Drill Holes<br/> <input type="checkbox"/> Fit/Function         </div> <div style="flex: 1;"> <input type="checkbox"/> Power Loss/Surge<br/> <input type="checkbox"/> Folio/Program<br/> <input type="checkbox"/> Grain Direction<br/> <input type="checkbox"/> Weld<br/> <input type="checkbox"/> Wrong Stock Pulled<br/> <input type="checkbox"/> Out of Sequence<br/> <input type="checkbox"/> Off-set/Set-up         </div> <div style="flex: 1;"> <input type="checkbox"/> Positioned Wrong<br/> <input type="checkbox"/> Outside Tolerance<br/> <input type="checkbox"/> Drawing<br/> <input type="checkbox"/> Finish<br/> <input type="checkbox"/> Part Lost/Missing<br/> <input type="checkbox"/> Misread         </div> </div> |  |                        |  |
| Other/Details: _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |  |                        |  |



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Container No: S312065



Part: 646.9702

Job No: 214164

Serial No/Batch: S312065

Revision: REV.J

Inspector:

Exp Date:

Instructions:

Date: 11/10/20